

Work Order ID 146097

Friday, May 06, 2016 8:59:29 AM

146097

Page 1

Item ID: D350-607-543

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Check Comp

Start Date: 4/26/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: MAY 09 2016 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D350-607-3	D
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DSI9699	A
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100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D350-607-543 CHG008

DAS
27
9-89

AUG 11 2016

117

Pick Kit

0.00

117

Packaging

Memo

0.00

Packaging

① R

DAS
28
9-89

AUG 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step # : _____		QTY Effective : _____			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : _____							

Work Order ID 146097

Friday, May 06, 2016 8:59:29 AM

146097

Page 2

Item ID: D350-607-543 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Cheek Comp
Start Date: 4/26/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 5/6/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.03							
Quality Control									
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Install placard and label as per dwg.								
	Package as per PPPD350-607-543								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.10							
Quality Control									

DAS
27
9-89
AUG 11 2016DAS
27
9-89
AUG 11 2016

16/8/11

JHA AUG 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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Picklist Print

Friday, May 06, 2016 8:59:28 AM

Page 1

Work Order ID: 146097

146097

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 4/26/2016

Required Date: 5/6/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 10-08-19 AS PER REV.A DD VERF BY:EC IPP
REV:B 12.03.06 AS PER ECN12-535 DD VERF:EC IPP REV:C
12.07.24 AS PER ECN 12-610 DD VERF:EC IPP Rev:D 13.07.08 as
per CHG005 (ECN13-582) DD verf:JLM IPP REV:E 13.08.21 CHG006 /
ECN 13-624 DD VERF:JLM IPP REV:F 14.06.09 AS PER ECN14-572
DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4917-315 *D4917-315* Placard, Max Load		Manufactured	No				Each	7.0000		1			PC
									**				DAS 28 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST137			7					
					134787			7					
D350-607-511 *D350-607-511* Quick Release Basket and Long Cargo Tube Mounting Provisions, Fits LH or RH		Manufactured	No				Each	4.0000					PC
									**				DAS 28 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					PK015			4					
					142811			2					
					142812			2					
D2690-6 *D2690-6* Lanyard		Manufactured	No				Each	1.0000					PC
									**				DAS 28 9-89
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST009			1					
					144944			1					

MAY 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
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Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Picklist Print

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Page 2

Work Order ID: 146097

146097

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 4/26/2016

Required Date: 5/6/2016

D3912-041

Manufactured No

Each

7.0000

Start Qty: 1.00

Required Qty: 1.00

D3912-041

Eyebolt Receiver Assy

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST057

7

144827

7

D4030-043

Manufactured No

Each

0.0000

D4030-043

Long Basket Assembly, Light Lid (350)

**

D4086-215

Manufactured No

Each

11.0000

D4086-215

Placard Max Load

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST078

11

140765

6

144164

5

D4151-041

Manufactured No

Each

12.0000

D4151-041

Basket Fwd Hardpoint Assembly, Lower

**

DAS
27
9-89

Location

Loc Qty

Loc Code

ST087

4

143337

1

143338

3

ST090A

8

143335

4

143336

4

1
B145537 PC DAS 28 9-89

1
B145700 DAS 28 9-89

1
PC DAS 28 9-89

1
B145589 PC DAS 28 9-89

AUG 11 2016

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Parent Item Name: Quick Release Heli-Utility-Basket™ Long,Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 4/26/2016

Required Date: 5/6/2016

D4151-043

Manufactured No

Each

13.0000

Start Qty: 1.00

Required Qty: 1.00

D4151-043

Basket Fwd Hardpoint Assembly, Upper

**

①
X B 146060 PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST088

3

143357

3

ST090A

10

143358

4

143359

4

143360

2

D4150-041

Manufactured No

Each

13.0000

D4150-041

Attachment Arm Assembly

**

①
X B 145783 PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST087

2

142612

2

ST090A

11

143343

4

143344

4

143345

3

AN4-13A

Purchased No

Each

389.0000

AN4-13A

Bolt

**

⑥
X M 135390 PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

36

m134167

36

over003

300

m134634

300

ST344

33

m134497

33

AUG 11 2016

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Shop Packet Print

Page 3

DQA: _____ Date: _____



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Root Cause				FAULT CATEGORY			
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Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

Friday, May 06, 2016 8:59:28 AM

Page 4

Work Order ID: 146097

146097

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long,Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 4/26/2016

Required Date: 5/6/2016

AN4C15

Purchased

No

Each

45.0000

Start Qty: 1.00

Required Qty: 1.00

AN4C15

Bolt

**

1

PC DAS 28 9-89

Location

Loc Qty

Loc Code

over003

32

M1134567

20

M134257

12

ST343

13

M133694

13

AN310C4

Purchased

No

Each

71.0000

AN310C4

Nut

**

1

PC DAS 28 9-89

Location

Loc Qty

Loc Code

OVER007

30

M134370

30

ST331

41

M133990

41

MS17984-C413

Purchased

No

Each

48.0000

MS17984-C413

Quick Release Pin

**

1

PC DAS 28 9-89

Location

Loc Qty

Loc Code

over005

40

m134052

10

m134528

10

m13462710

10

m134664

10

ST315

8

m133686

8

AUG 11 2016

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Shop Packet Print

Page 4

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Picklist Print

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Page 5

Work Order ID: 146097

146097

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 4/26/2016

Required Date: 5/6/2016

MS21042L4

Purchased No

Each

Start Qty: 1.00
1,670.000

Required Qty: 1.00

MS21042L 4

Locknut

**

6
xm 135127 PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

279

m133769

279

OVER007

500

m134676

500

ST303

794

m134606

794

ST305

97

m130922

97

MS24665-151

Purchased No

Each

153.0000

MS24665-151

Cotter Pin

**

1 PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

64

m128401

64

ST289

89

m134294

89

NAS1515H4L

Purchased No

Each

323.0000

***NAS1515H4L ***

Washer

**

2 PC DAS 28 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FG

23

103691

3

m132189

20

ST260

300

m133483

200

m134376

100

AUG 11 2016

Friday, May 06, 2016 8:59:29 AM

Shop Packet Print

Page 5

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
				OTHER : ☐			

Picklist Print

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Page 6

Work Order ID: 146097

146097

Parent Item: D350-607-543

D350-607-543

Parent Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 4/26/2016

Required Date: 5/6/2016

NAS1149F0432P

Purchased

No

Each

Start Qty: 1.00
1,378.000

12

Required Qty: 1.00

NAS1149F0432P

WASHER

**

PC

DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST260a

1000

M134502

1000

ST262

257

M133990

257

st268

121

M132677

121

12

NAS1149C0463R

Purchased

No

Each

334.0000

3

NAS1149C0463R

Washer

**

PC DAS
28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

70

m127306

70

ST260a

200

m134167

200

ST266

64

m133077

64

3

AUG 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-607-3 Rev.D,
 INSTALLATION INSTRUCTIONS D350-607-4 Rev. C AND
 INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-607 REV. 6
 REF TCCA STC: SH94-14
 REF FAA STC: SR00213NY
 REF EASA STC: EASA.10016996
 REF BRAZILIAN STC: 2007S03-03/-04/-05/-06

INSTRUCTIONS COPY
 TO BE KEPT IN THE
 WORK CENTER
 160503
 146097 MS

1.0 PURPOSE

This service instruction provides parts and instructions to facilitate installation of forward Basket Strut for customers that have purchased: D350-607-501 Conversion Kit @ CHG 004, D350-607-511 Quick Release Basket Mounting Kit @ CHG 004, D350-607-541 @ CHG 006, D350-607-543 @ CHG 007, D350-607-545 @ CHG 006, D350-607-547 @ CHG 007 Heli-Utility-Baskets as well as the D350-607-431 Strut Retrofit Kit and the D350-607-641 Long Cargo Tube @ CHG 001.

2.0 PARTS LIST:

Modify the quantities for D3910-5 and add D3910-7 as follows:

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET @ CHG 007 OR LATER
	X					D350-607-543	HELI-UTILITY-BASKET @ CHG 008 OR LATER
		X				D350-607-545	HELI-UTILITY-BASKET @ CHG 007 OR LATER
			X			D350-607-547	HELI-UTILITY-BASKET @ CHG 005 OR LATER
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
					X	D350-607-501	CONVERSION KIT @ CHG 005 OR LATER
				1	1	D3910-5	X-TUBE LUG
				1	1	D3910-7	X-TUBE LUG

(ADD)

QTY -413	QTY -415	QTY -417	QTY -419	QTY -431	PART NUMBER	DESCRIPTION
X					D350-607-413	HEAVY DUTY LID KIT (LONG)
	X				D350-607-415	HEAVY DUTY LID KIT (SHORT)
		X			D350-607-417	LIGHTWEIGHT LID KIT (LONG)
			X		D350-607-419	LIGHTWEIGHT LID KIT (SHORT)
				X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
				1	D3910-5	X-TUBE LUG
				1	D3910-7	X-TUBE LUG

(ADD)

QTY -641	QTY -611	QTY -511	QTY -431	PART NUMBER	DESCRIPTION
X				D350-607-641	QUICK RELEASE LONG CARGO TUBE
1	X			D350-607-611	LONG CARGO TUBE
1		X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT @ CHG 005 OR LATER
			X	D350-607-431	STRUT RETROFIT KIT @ CHG 005 OR LATER
		1	1	D3910-5	X-TUBE LUG
		1	1	D3910-7	X-TUBE LUG

(ADD)

CANADA
 DEPARTMENT OF TRANSPORT
 AIRCRAFT CERTIFICATION
 BRANCH
 DAO # 01-Q-01

APPROVED

BY: 
 D. SHEPHERD (DE # 02)

DATE: 14.05.16
 CERT. NO.: SH94-14
 ISSUE NO.: 6

A	NEW ISSUE	AJS	14.05.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

3.0 PROCEDURE:

Install the D350-607-501 Conversion Kit, D350-607-511 Quick Release Mounting Kit or D350-607-431 Strut retrofit kit per Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C. While installing the Forward Strut perform the following:

- 3.1 Substitute the Forward Lower D3910-5 X-Tube Lug with the D3910-7 X-Tube Lug as shown in Figure 1.
- 3.2 Install the forward D4775-041 Strut Assembly. Transfer mark from the upper hole on the clevis of the D4775-041 Strut Assembly to the D3910-7 X-tube Lug and drill thru the lug $\varnothing 0.257$ - $\varnothing 0.261$ as shown in Figure 1. Touch up chemical conversion coating per MIL-DTL-5541. Check the witness holes located at the bottom end of the D4775-041 Strut Assemblies to ensure that the thread from the rod end extends past the witness hole.
Torque MS21042L4/-4 nuts to 50-70 in-lbs (5.7-7.9 N-m). Torque MS21042L6/-6 nuts to 160-190 in-lbs (18.1-21.5 N-m).
- 3.3 Complete the installation in accordance with Installation Instructions D350-607-3 Rev. D or D350-607-4 Rev. C.

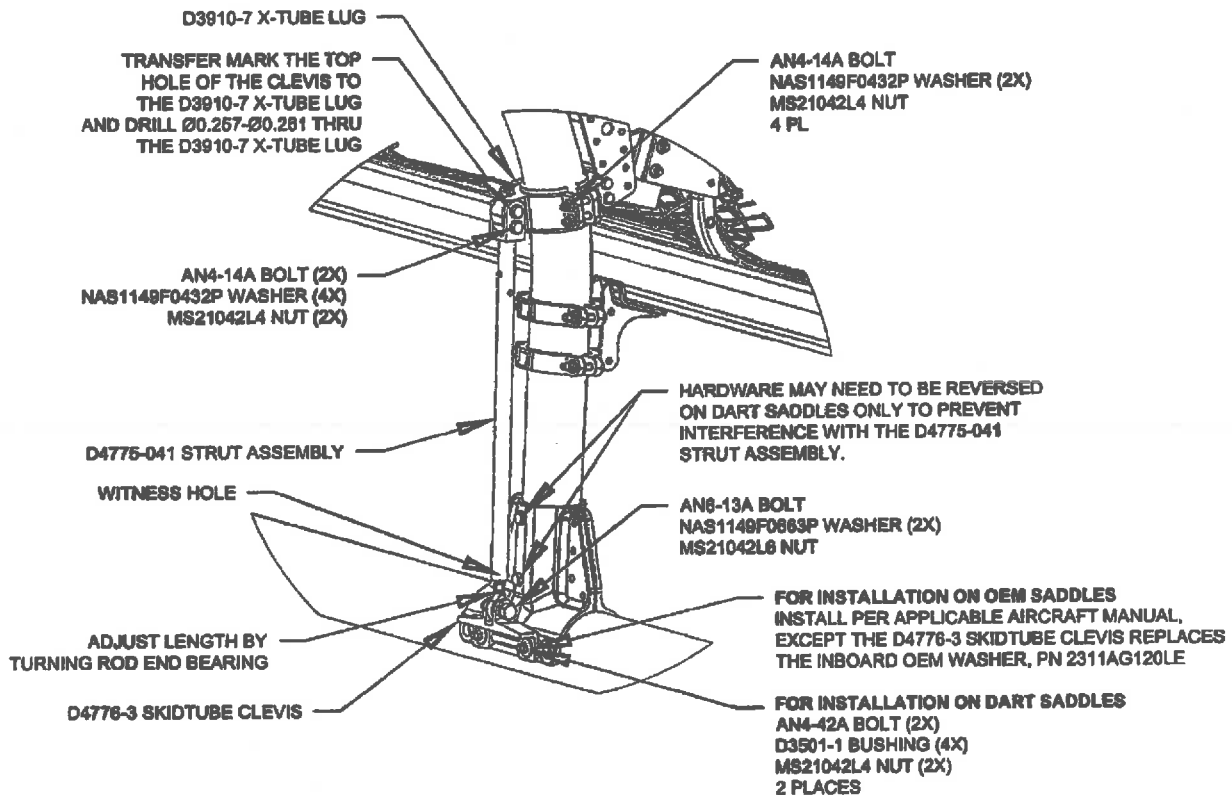


FIGURE 1: INSTALLATION OF D4775-041 FWD STRUT

4.0 WEIGHT AND BALANCE:

There is no weight and balance change associated with this update.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 14.05.16
CERT. NO.: SH94-14
ISSUE NO.: 6

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9699	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG REPLACEMENT	NTS
DATE	14.05.16	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

5.0 PARTS LIST

QTY -541	QTY -543	QTY -545	QTY -547	QTY -511	QTY -501	PART NUMBER	DESCRIPTION
X						D350-607-541	HELI-UTILITY-BASKET
	X					D350-607-543	HELI-UTILITY-BASKET
		X				D350-607-545	HELI-UTILITY-BASKET
			X			D350-607-547	HELI-UTILITY-BASKET
1	1	1	1	X		D350-607-511	QUICK RELEASE BASKET MOUNTING KIT
					X	D350-607-501	CONVERSION KIT
1	1	1	1		1	D2690-6	LANYARD
				8	8	D3501-1	BUSHING
				2	2	D3910-3	X-TUBE LUG
				2	2	D3910-5	X-TUBE LUG
1	1	1	1		1	D3912-041	EYEBOLT RECEIVER ASSY
				8	8	D3984-030	RUBBER EXTRUSION, X-TUBE
1						D4030-041	LONG BASKET ASSY
	1					D4030-043	LONG BASKET ASSY, LIGHTWEIGHT
		1				D4032-041	SHORT BASKET ASSY
			1			D4032-043	SHORT BASKET ASSY, LIGHTWEIGHT
1					1	D4917-300	PLACARD, MAX LOAD
1						D4086-200	PLACARD, MAX LOAD
	1				1	D4917-315	PLACARD, MAX LOAD
	1					D4086-215	PLACARD, MAX LOAD
		1			1	D4917-320	PLACARD, MAX LOAD
		1				D4086-220	PLACARD, MAX LOAD
			1		1	D4917-332	PLACARD, MAX LOAD
			1			D4086-232	PLACARD, MAX LOAD
				1	1	D4148-041	FWD X-TUBE LUG ASSY
				1	1	D4149-041	AFT X-TUBE LUG ASSY
1	1	1	1		1	D4150-041	ATTACHMENT ARM ASSY
1	1	1	1		1	D4151-041	BASKET FWD HARDPOINT ASSY (LOWER)
1	1	1	1		1	D4151-043	BASKET FWD HARDPOINT ASSY (UPPER)
				2	2	D4775-041	STRUT ASSEMBLY
				2	2	D4776-3	SKIDTUBE CLEVIS
6	6	6	6		6	AN4-13A	BOLT
				20	22	AN4-14A	BOLT
				4	4	AN4-42A	BOLT
1	1	1	1		1	AN4C15	BOLT
1	1	1	1		1	AN310C4	CASTELLATED NUT
				2	2	AN6-13A	BOLT
1	1	1	1		1	MS17984-C413	QUICK RELEASE PIN
6	6	6	6	24	32	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21042L6	NUT
1	1	1	1		1	MS24665-151	COTTER PIN
2	2	2	2		2	NAS1515H4L	WASHER
12	12	12	12	40	56	NAS1149F0432P	WASHER
3	3	3	3		3	NAS1149C0463R	WASHER
				4	4	NAS1149F0663P	WASHER

Work Order ID 146097

Friday, May 06, 2016 8:59:29 AM

146097

Page 1

Item ID: D350-607-543

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Quick Release Heli-Utility-Basket™ Long, Light Lid, Spacepod™/Squirrel Cheek Comp

Start Date: 4/26/2016 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: ML5 Date: MAY 09 2016

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D350-607-3	D								
DSI9699	A								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPP D350-607-543 CHG008								
117	Pick Kit	0.00							
117									
Packaging	Memo	0.00							
Packaging									

used white and red label
phase 1 by AUG 11 2016

 AUG 11 2016